

Date: Monday, 5/15/2006 10:44:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 27092A		
Estimate Number	: 11703		
P.O. Number	: NIA	Part Number	: D2724042
This Issue	: 5/15/2006	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D2724 REVC
First Issue	: NIA	Project Number	: N/A
Previous Run	: 26487A	Drawing Revision	: C
	Type : LARGE FAB ASSY	Material	: NIA
Written By	: <i>See Comment Below</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>06.05.15</i>	Qty:	4 Um: Each
Comment	: Est Rev:E As Per Ech 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion	<i>327077</i>
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Check Material for any Dents or Defects

PE 06.05.26 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

PE 06.05.26 4
PE 06.05.26 4

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
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2	D2734	End Cap	<i>324402</i>
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PE 06.06.31 4

4.0	D34581	PLATE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D3458-1	Plate	<i>327128</i>
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PE 06.06.1 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:44:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 27092A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3458-3

Plate

326779 = 4

327253 = 4

PE. 06.06.1

4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD

Batch:

M19173

M15689

Grind end cap welds flush

PE. 06.06.1

4

FF 06.06.02

4

7.0

QC5/9

WELD INSPECTION



PD 06.06.08

4

Comment: WELD INSPECTION

06.06.05

4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06.06.10

4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06.06.12

4

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD

Batch:

M15689

PE. 06.06.13

PE. 06.06.13

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-06-14	10a	grid end plate flush as per dwg.	FH/E	06-06-14	1/3			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:44:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 27092A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



10 06-06-15

J 06-06-15

Comment: WELD INSPECTION

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

HM 06-06-15

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/19

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 060620

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

FC 060620

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16/6/27

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

NA

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

0606127

Job Completion



12 06-06-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

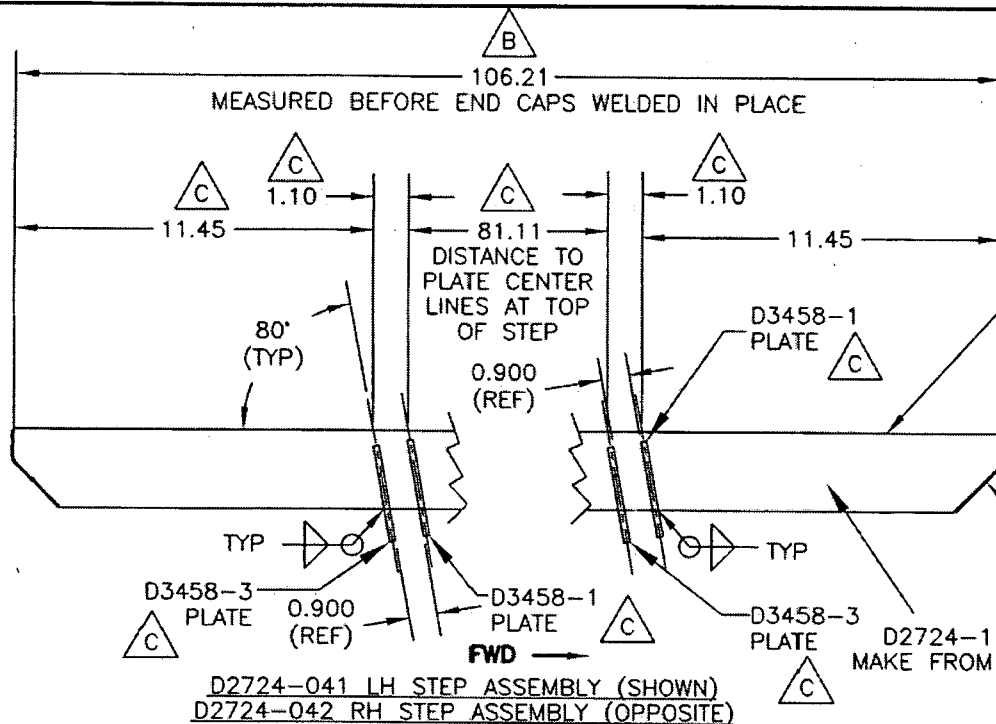
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
05.11.14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS



— REFER TO STEP
END DETAIL

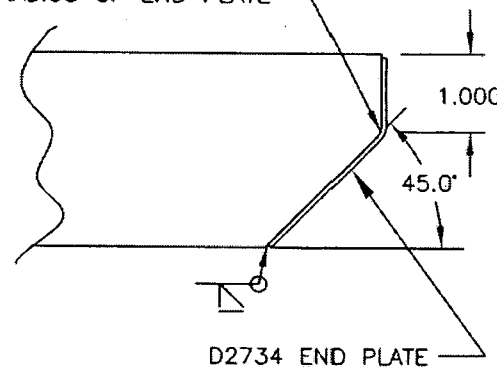
D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMENDM
WITHOUT NOTICE
WORK ORDER
NO. 27092A
PLATE

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